

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: OUTSIDE WASHER		
Job Number	: 34176				
Estimate Number	: 11153				
P.O. Number	: N/A	Part Number	: D32333		
This Issue	: 8/21/2007	S.O. No.	: N/A	Drawing Number	: D3233 REV B
Prsht Rev.	: NC			Project Number	: N/A
First Issue	: N/A	Type	: MACHINED PARTS	Drawing Revision	: B
Previous Run	: 28611			Material	: N/A
Written By	: <u>[Signature]</u>	Due Date	: 9/10/2007	Qty:	20
Checked & Approved By	: <u>[Signature]</u>			Um:	Each
Comment	: Est. B 05.03.31 Added Powder CoatKJ/JLM				

Job Number:

Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

10	M1020TR2000W500	1020-1025 Round Tube
----	-----------------	----------------------

Comment: Qty.: ~~8.7875 f(s)~~ Unit Total : 7.8750 f(s)
1020-1025 Round Tube
Material: AISI 1020-1025 Seamless Tubing 2" x 0.500" wall
(M1020TR2.000W.500)
Identify for D3233-3
Batch: M102210

20	HARDINGE	HARDINGE CNC LATHE SMALL
----	----------	--------------------------

Comment: HARDINGE CNC LATHE SMALL
Turn as per Folio FA518 and Dwg D3233.
Deburr

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

40 QC8 SECOND CHECK

Comment: SECOND CHECK

5.0	POWDER COATING	POWDER COATING
-----	----------------	----------------

Comment: POWDER COATING
Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: PD Date: 07/09/21
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 8/21/2007 3:42:58 PM
User: Kim Johnston

Process Sheet

✓ Customer: CU-DAR001 Dart Helicopters Services Drawing Name: OUTSIDE WASHER

Job Number: 34176

Part Number: D32333

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8/19/20 (20)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

CALL *8/19/20* (20)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(21) *207/09/21*

Job Completion



U 8/29/21

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

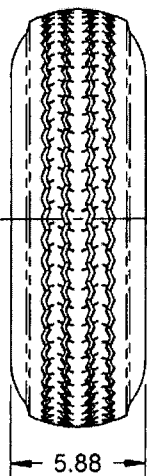
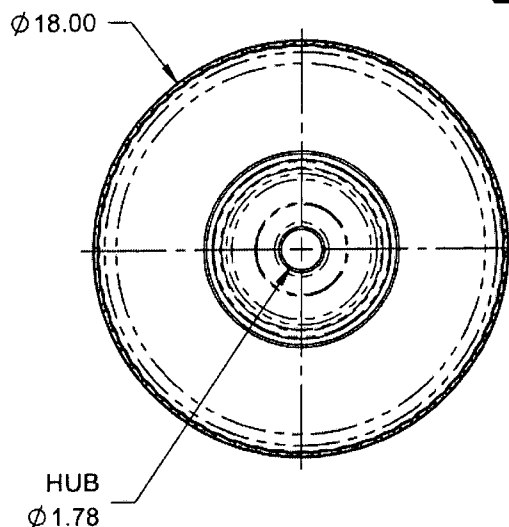
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

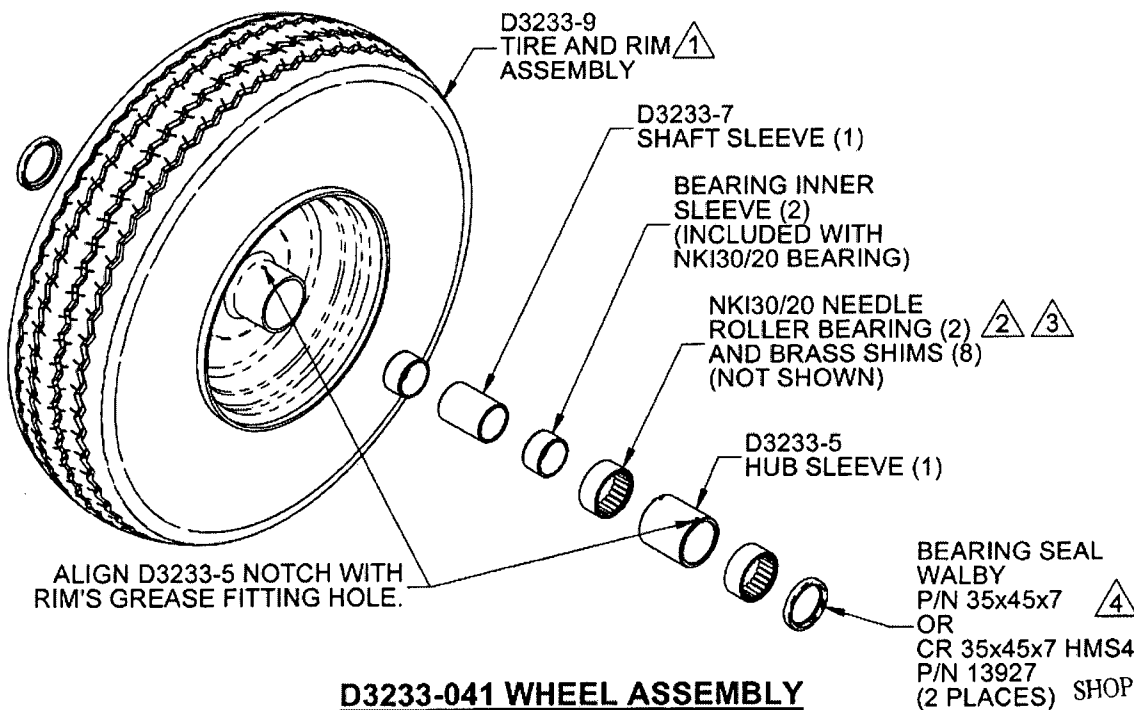
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3233	REV. B SHEET 1 OF 3
DATE	05.03.08	TITLE WHEEL ASSEMBLY	SCALE 1:1
A	05.02.18	NEW ISSUE	
B	05.03.08	ADDED BEARING SEALS	



RELEASED
05/05/04

WHEEL SPECIFICATIONS		
SIZE	MAXIMUM LOAD	MAXIMUM INFLATION LOAD
TIRE: 19.0 x 5.8 RIM: 5.70 x 8.0	910 LBS (RANGE C)	90 PSI*

* MANUFACTURER'S RECOMENDATIONS
ARE 75 PSI FOR HIGH SPEED USE.



D3233-041 WHEEL ASSEMBLY

NOTES:

- 1) POSSIBLE SUPPLIER: McMASTER-CARR, P/N 8353T74
- 2) POSSIBLE SUPPLIER: GENERAL BEARING
- 3) PRESS FIT NEEDLE ROLLER BEARINGS INTO RIM HUB WITH
(4) 0.5 X 0.75 X 0.004 BRASS SHIMS PER BEARING, (1) AT EACH QUADRANT.
- 4) POSSIBLE SUPPLIER: GENERAL BEARING
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

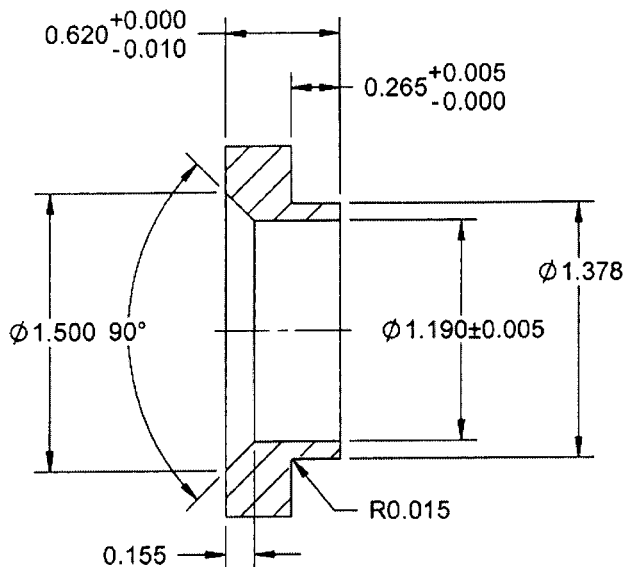
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. **34176**

COPYRIGHT © 2005 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

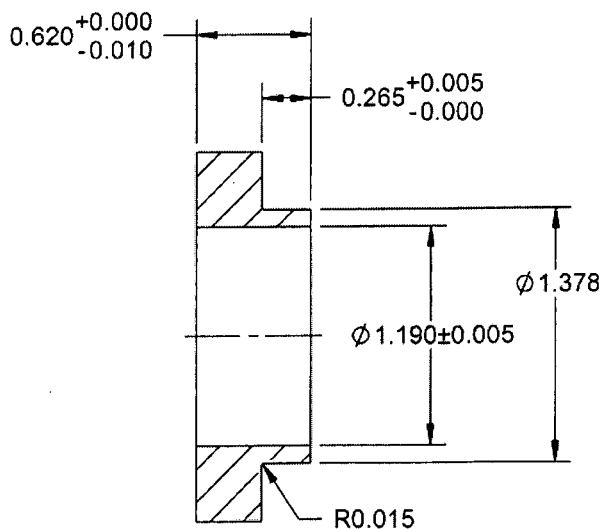
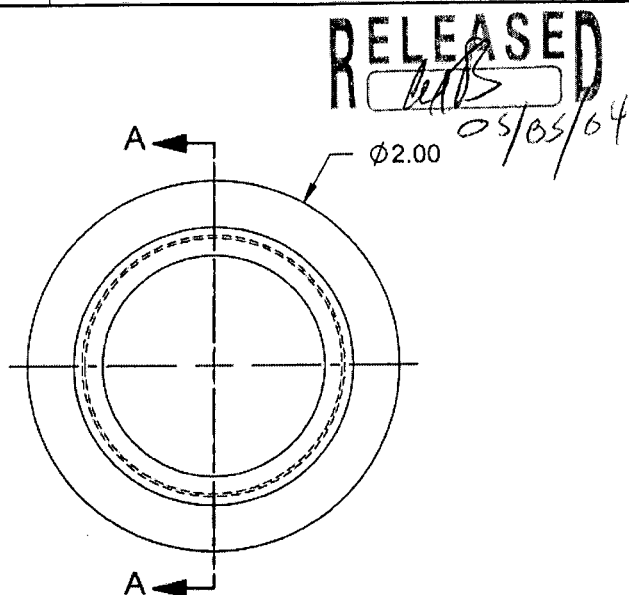


DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3233	REV. B SHEET 2 OF 3
DATE 05.03.08		TITLE WHEEL ASSEMBLY	SCALE 1:1



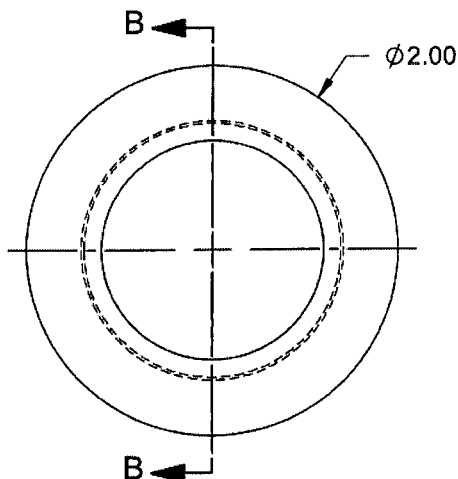
SECTION A-A

D3233-1 INSIDE WASHER



SECTION B-B

D3233-3 OUTSIDE WASHER



NOTES:

- 1) MATERIAL: AISI 1020-1025 ROUND TUBING PER MIL-T-5066 OR ASTM A513-00 MT1020 SRA OR AMS 5075 OR AMS 5077, COLD DRAWN, SEAMLESS (REF. DART SPEC. M1020TR)
- 2) FINISH: POWDER COAT FIRE RED (REF. 4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

SHOP COPY
RETURN TO
ENGINEERING
CONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. **34176**

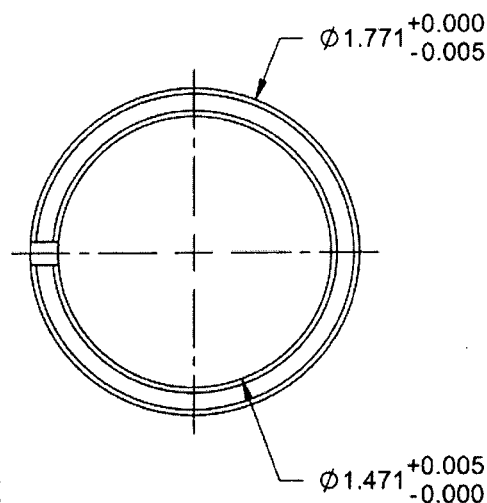
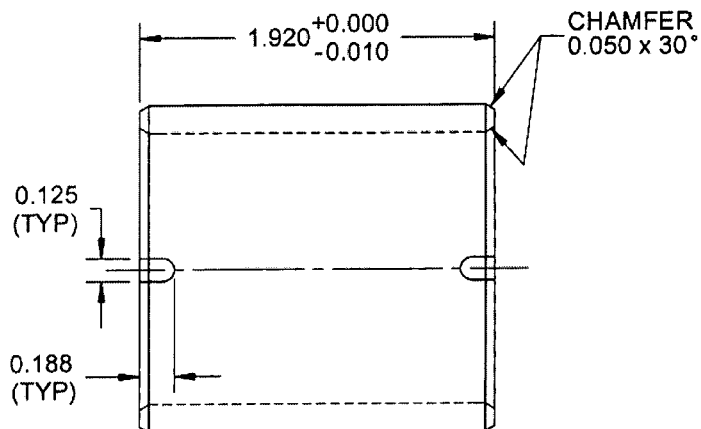
COPYRIGHT © 2005 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

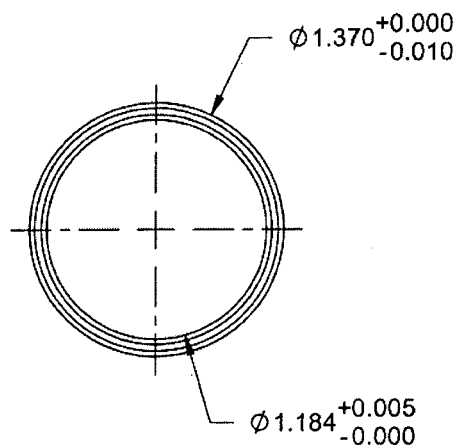
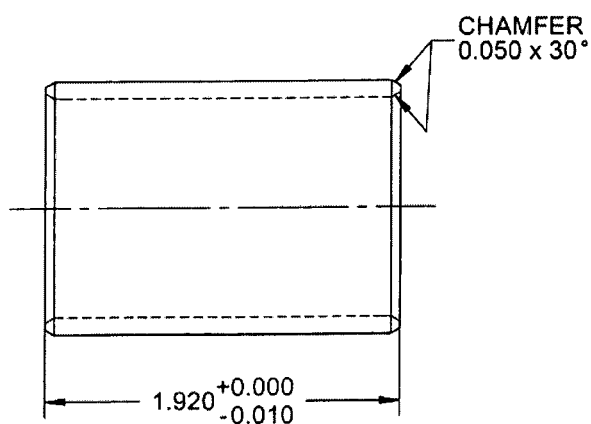


DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3233	REV. B SHEET 3 OF 3
DATE 05.03.08		TITLE WHEEL ASSEMBLY	SCALE 1:1

RELEASED
[Signature]
05/05/04



D3233-5 HUB SLEEVE



D3233-7 SHAFT SLEEVE

NOTES:

- 1) MATERIAL: AISI 1020-1025 ROUND TUBING PER MIL-T-5066 OR ASTM A513-00 ENGINEERING
MT1020 SRA OR AMS 5075 OR AMS 5077, COLD DRAWN, SEAMLESS
(REF. DART SPEC. M1020TR)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.030

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 34176

COPYRIGHT © 2005 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.